

Date: Monday, 02/10/2006 7:16:06 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number : 28805	
Estimate Number : 10534	
P.O. Number : <i>NA</i>	Part Number : D2574
This Issue : 02/10/2006 S.O. No. : <i>N/A</i>	Drawing Number : D2574 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 28447	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 09/10/2006 Qty: 4 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev: 1 As Per RevE 06-01-27 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 7075-T7351 8.25X5.0X2.5
 Make from D6101-005 billet for D2574
 Ensure that grain is along 5.00" length
 Batch No: *B25357*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. *28805* Double check by: *MS*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove sharp edges.

J.G. Am 06/10/03 4

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2573 & D2574

J.G. 06/10/04 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 17 Date: 06/18/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/10/2006 7:16:06 AM
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Seq. #:	Machine Or Operation:	Description :
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4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.G 06/01/04 4

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 06/10/05 x4

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

Y 06/10/05 x4

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06/10/10 (4)

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

06/10/11 (4)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 57480

06/10/11 (4)

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

06/10/11 (4)

Job Completion



06/10/11

Dart Aerospace Ltd

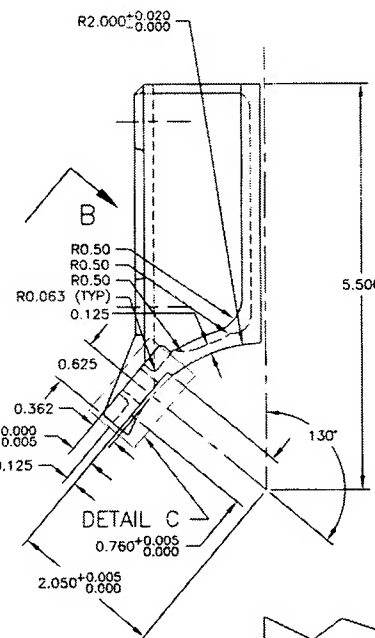
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

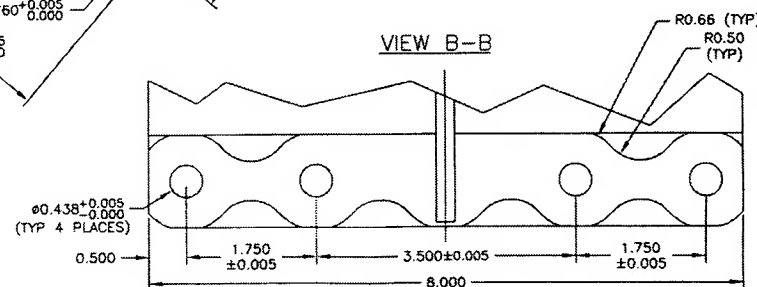
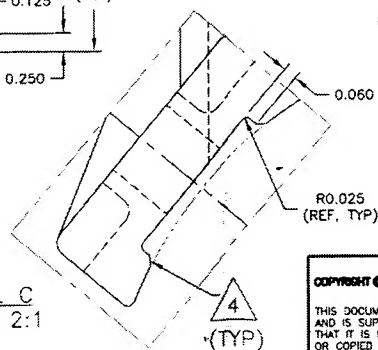
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



05.2.50

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)



REFERENCE ONLY

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 28805
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.752	1.751	1.751	1.751		
C	3.495	3.505		3.500	3.499	3.499	3.498		
D	1.745	1.755		1.751	1.751	1.750	1.750		
E	7.990	8.010		8.006	8.005	8.006	8.006		
F	0.490	0.510	DT8683 DT8684	0.502	0.508	0.500	0.501		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.376	0.376	0.376	0.376		
I	0.490	0.510		0.506	0.506	0.506	0.501		
J	1.174	1.184		1.179	1.179	1.179	1.180		
K	0.558	0.578		0.569	0.567	0.567	0.569		
L	1.174	1.184		1.180	1.179	1.180	1.180		
M	1.365	1.375		1.369	1.368	1.369	1.369		
N	2.495	2.505		2.499	2.499	2.500	2.499		
O	4.119	4.129		4.123	4.122	4.124	4.123		
P	0.115	0.135		0.123	0.122	0.121	0.121		
Q	0.115	0.135		0.134	0.135	0.135	0.134		
R	0.240	0.260		0.254	0.255	0.254	0.254		
S	0.115	0.135		0.117	0.118	0.117	0.119		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.231	3.232	3.232	3.231		
V	0.230	0.250		0.240	0.241	0.240	0.240		
W	0.115	0.135		0.124	0.124	0.123	0.122		
X	0.307	0.312		0.311	0.310	0.310	0.310		
Y	0.760	0.765		0.761	0.761	0.761	0.761		
Z	0.352	0.372		0.364	0.363	0.365	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.629	0.628	0.627	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.256	0.256	0.254		
AE	1.500	1.520		1.507	1.510	1.510	1.510		
AF	0.115	0.135		0.135	0.135	0.135	0.134		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.255	0.255	0.254	0.254		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: J.G
Date: 06/10/03

Audited by: E
Date: 06/10/05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	